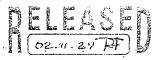
5/15

115	SPLIT			
DART AEROSPACE LTD	Work Order:	228341		
Description: Ø2.750 Support	Part Number:	D2893-1		
Dwg: D2893 Rev. A1	Qty:	6 70		
		Page 1 of 1		

3.06.09

					
Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveller Blank size makes (2) D2893-1 2 Dwg not required	19	05.03.23	10
2	PG	Issue P/O: 100418 f Description: D6104-005 Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104 Material release note required.	u	80374	w
3	RG	Receive and Inspect for raw material dimensions. Ensure material release note is attached.	CL	05/04/04	10
4	MS	Turn blank for Haas as per Folio FA081	9m2	05/04/05	3
5	QC1	Inspect all dimensions as per Dwg D2893	me	05/04/06	3
6	MV	Machine as per Folio FA081	me	05/04/12	3
7	MV	Tumble & Deburr	Ind	05/04/12	3
8	QC1	Inspect all dimensions to inspection sheet as per Dwg D2893	The	05/04/12	3
9	QC8	Inspect dimensions for second check	En	05/04/12	3.
10	FP	Powder Coat White (4.3.5.2) per QSI 005 4.3	M	05 04 12	3
11	QC3	Inspect Powder Coat	CL	05/04/14	5.4
12	ST	Identify and stock	CL	05104/14	36
13	AC	Cost / part / 23, 95	Soc	05-04-19	6
14	DC	Close W/O / Z Z , Y 8 Inspect Level 21	18	65.04.19	6

Rev	Date	Change	Revised By	Approved
Α	01.01.08	Preliminary Issue	EC	
В	01.07.19	Heat treat removed	NG	
С	02.11.26	Reformat; Added P/O	KJ/RFKF	



AEROSPACE LTD		Work Order:	22834
Jescription: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893 Rev. A1			Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Lathe Section									
Α	2.707	2.712		2,712	2.711	2.712			
В	4.946	4.966		4.955	4.964	4.956			
С	3.064	3.084		3,075	3.073	3,075			
D	0.718	0.738		0.725	0.726	0.726			
E	0.090	0.110		0.104	0.101	0.101			
F	2.934	2.954			2,946	2.946			
G	2.166	2.186		2.177	2.182	20173			
Н	3.890	3.910		3,900	3.899	3.900			
1	0.914	0.934		8.928	0.927	0,930			
J	0.022	0.042	•	0.032	0.032	0.032			
K	0.109	0.129		0.115	0.116	0.115			
L.						1 .		*	
				HAA	S Section			·	
AA	2.985	3.005		3.000	2 995	2.995			
AB	0.440	0.460		0.440	0.440	0.440			
AC	0.125	0.160		0.136	0.150	0.140			
AD	0.040	0.060		0.040	0,040	0.040			***************************************
AE	0.188	0.193	DT8706	0.189	0.198	0.188	***************************************		
AF	0.125	0.160		0.143	0.147	0.145			
AG	0.140	0.160		0.157	0.147	0.149			
AH	1.360	1.400		1.386	1.389	1.381	·····	7.	
Al	0.040	0.060		0.045	0.042	0:045		/	
AJ	1.190	1.230		1.227	1.223	1.226			
AK	0.010	0.020		0.010	0.010	0.010			
AL	0.053	0.073		0.063	0.063	0.063			
AM	0.240	0.260		0.250	0.250	0.250			
AN	2.518	2.538		2.528	2.528	2.528			
AO	84.39	90.39	DT8699		87				
AP	0.257	0.262	DT8683	0.257	0.258	0.258		1	
AQ	0.053	0.073		0.062	0.063	0.063			
AR									
AS	-	•							
	Acc	ept/Reje	ct						,

		·			
Measured by:	In In		Audited by	cr.	
Date:	05/04/04		Date:	05/04/12	
· · · · · · · · · · · · · · · · · · ·	<u> </u>				

Rev	Date	Change	Revised by	Approved
Α	02.12.13	New Issue	KJ/RF →	

